Work Order ID 64827

Friday, December 17, 2010 8:05:01 AM



Page 1

Item ID:

D3208-1

Accept

Setup Start



Revision ID:

Item Name: Doubler

Required Date: 1/19/2011

12/16/2010 Start Qty: -6.00

Cust Item ID: Customer:

Reference:

Start Date:

Approvals:

Date: 10-12-17

Tooling:

Date:

Run

Start

Stop

Stop



QC:

Req'd Qty: 6.00

Date:

SPC (Y/N):

Tool # Plan

Reject Qty

Reject

Insp.

Sequence ID/ Work Center ID

Operation Description Set Up/ **Run Hours** **Tool ID**

Date:

Code

Accept

Number

Stamp

Draw Nbr D3208

Rev A1

100

SHEAR

Revision Nbr

Shear

Memo

0.00

0.00

Shear

Cut blank: 4.038" X 5.340" grain along 4.038" Gldentify for D3208-1

Qty

110

Small Fab

0.00

0.00

Small Fab Small Fab

Drill and Fillet D3208-1 corner as per Dwg D3208□Identify as D3208-1

120

NC BRAKE

0.00

Brake NC

Brake NC

Memo

Memo

0.00

Deburr D3208-1□Form D3208-1 as per Dwg D3208□Polish any marks on part

within 01. of Dwg D3208

W/O:			WORK ORDER	CHANGES				•	74
DATE	STEP	PR	OCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No):	PAR #:	Fault Category:	NCI	R: Yes	No DQ	A:	Date: _	
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NCR:			WORK ORDER NON-CONFORMANCE (NCR)									
DATE STEP		Corrective Action Section B				Verification	Annroyal	Approval				
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Work Order ID 64827

Friday, December 17, 2010 8:05:01 AM



Page 2

Item ID:

D3208-1

Accept

Setup Start

Revision ID:

Item Name:

Required Date: 1/19/2011

Doubler

12/16/2010

Start Oty: 6.00

Req'd Qty: 6.00

Date:____

Cust Item ID: Customer:

Reference:

Start Date:

Approvals:

Process Plan:

Date:

Tooling:

SPC (Y/N):

Date: Date:

Run

Start

Stop

Stop

Sequence ID/

Work Center ID

130

140

Quality Control

Operation Description

QC5- Inspect part completeness to step on W/O

Set Up/ **Run Hours**

0.00 Suladin Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Number

Insp. Stamp

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

Memo

0.00

HandFinish

Hand Finishing

150

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

8 BL 11-01-11.

Dart Aerospace L	Ltd
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W/O:			WO	RK ORDER CHANGE	ES			······································		
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		Description of NC		Corrective Action Section	on B		Verific	ation	Approval	Approval
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Work Order ID 64827

Friday, December 17, 2010 8:05:01 AM



Page 3

Item ID:

D3208-1

Accept

Setup Start



Revision ID:

Start Date:

Item Name: Doubler

Start Qty: 6.00 12/16/2010

Required Date: 1/19/2011

Req'd Qty: 6.00



Cust Item ID: Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



Date:____

SPC (Y/N):

Set Up/

Run Hours

Date:

Stop

Stop

Sequence ID/

Work Center ID

160

Packaging

Packaging

Operation Description

Identify as per dwg & Stock Location: 202

0.00

0.00

Tool ID

Tool # Plan Code

Reject Accept Qty Qty

Reject Number

Insp. Stamp

170

QC Quality Control QC21- Final Inspection - Work Order Release

0.00

Memo

Memo

0.00

W/O:	1		١٨	ORK ORDER CI	ANGES					· · · · · · · · · · · · · · · · · · ·
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Picklist Print

Friday, December 17, 2010 8:05:05 AM

Work Order ID: 64827

Parent Item: D

D3208-1

Parent Item Name: Doubler

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Sta. Date: 12/16/2010

Required Late: 1/19/2011

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP: B□04.05.25□Material changed for Step 4□KJ/JLM□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.040 2024-T3 .040 sheet		Purchased	No			100	sf	219.9400	0.1645	1.038947	1	11/0	1/10

Location	Loc Oty	Loc Code
MAT	30.2	
114415	30.2	
MAT22	189.74	
110305	21.93	
111786	9.66	
112291	28.25	
112331	52	
113162	77.9	

1-058947 1-4805

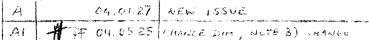
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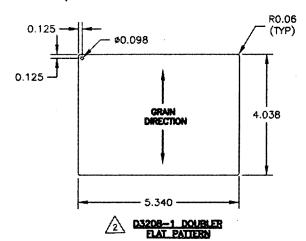
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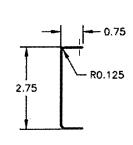
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3 D3208—3 PEDAL MOUNT ANGLE
ELAT PATIERN

DIRECTION

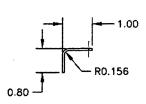


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SUBJECT TO AMENDMENT

WITHOUT NOTICE WORK ORDER



D3208-3 PEDAL MOUNT ANGLE BEND DETAIL

NOTES:

0.125

0.125

- 1) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040" THICK (M2024T3S.040)
- 3) MATERIAL: 2024-T3 (QQ-A-250/4)-0.063" THICK (M2024T3S.040)
 4) MATERIAL: 2024-T3 (QQ-A-250/4)-0.080" THICK (M2024T3S.080)
 5) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 7) ALL DIMENSIONS ARE IN INCHES



3) MATERIAL: 6061-TE (00-A-150/H) 0.063" THICK (MECELTES.061)

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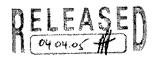
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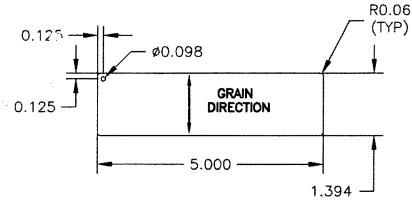
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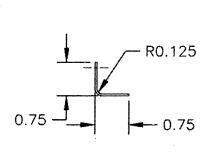




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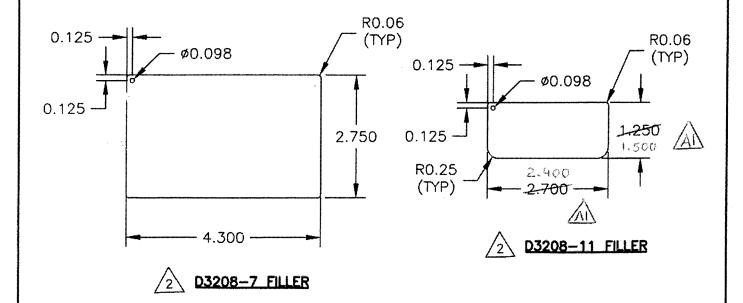




D3208-5 MOUNT ANGLE FLAT PATTERN

D3208-5 MOUNT ANGLE BEND DETAIL

WO 44827



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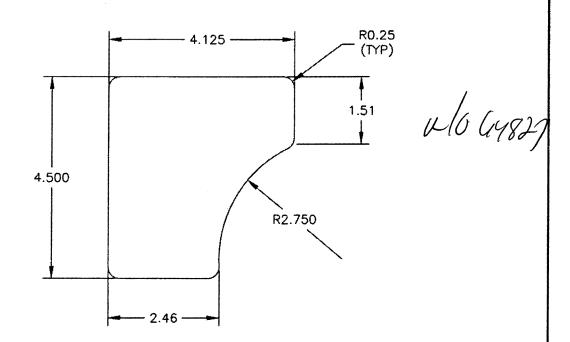
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D3208-9 DOUBLER

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